

Work Order ID 54818

December 22, 2009 1:27:24 PM



Page 1

Item ID: D3695-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Slider Assembly

Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CL

Date: 09/12/23

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3695

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- install heli-coil as per dwg D3695-12- install D3695-3 and spring plug as per dwg D3695

⇒ m-k 10/02/18

4X

P10

P10⇒

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

5.10/02/18

40

120

0.00



Identify as per dwg & Stock Location: _____

Packaging

Memo

0.00

Packaging

10/14/19 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3695-041 PAR #: _____ Fault Category: Finishing NCR: Yes ☒ No ☐ DQA: 7 Date: 10.02.03
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>54818</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.02.03	100	upon installation of the Heli-coil, it was noticed that the D3695-1 slider bars were not powder coated to drawing. 6 x B54822	<u>Q51042</u>	See NCR 10-015	<u>N/A</u>	<u>10.02.03</u>	<u>Q51042</u>	<u>10.02.03</u>
10/02/18	#100	During Assembly it was found that installing MS24693-C276 were near to impossible to use DL depth of hole right to l. and	<u>Q51042</u>	- Remove MS24693-C276 and replace with MS24693-C74 B2 <u>M118928</u> + l/b	<u>M.1</u> <u>10/02/18</u>	<u>10/02/18</u>	<u>Q51042</u>	<u>10/02/18</u>
		on slide D3695-1 and hole size on D3695-3. change plan . QUESTIONING PRODUCTION METHODS TO DO TAP DRILL/INSTALL HELICAL. DEPTH NOT PER DWG? HOW EXPLAIN		Scrap All used MS24693-C276 QTY + 18	<u>M.1</u> <u>10/02/18</u>	<u>10/02/18</u>		<u>10/02/18</u>

NOTE: Date & initial all entries START PROBLEM WITH THERM HOLE?

Work Order ID 54818

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Page 2

Item ID: D3695-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Slider Assembly

Start Date: 1/05/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/23 *[Signature]*

mf
10-2-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 54818

Parent Item: D3695-041

Parent Item Name: Slider Assembly

Start Date: 1/05/10

Required Date: 1/15/10

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3695-1 Manufactured No



Slider

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	2	
	46109	2	

2x m-l 10/02/02
2x m-l 10/02/02

D3695-3 Manufactured No



Stopper

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	2	
	44854	2	

2x m-l 10/02/02
2x m-l 10/02/02

D3801-1 Manufactured No



Hand Retractable Spring Plunger

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	11	
	40736	6	
	44537	5	

4x m-l 10/02/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 22, 2009 1:27:18 PM

Work Order ID: 54818

Parent Item: D3695-041

Parent Item Name: Slider Assembly


Start Date: 1/05/10

Required Date: 1/15/10

Comments:


Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21209-F120		Purchased	No				Each	44.0000	16.0000			
												
HELI COIL												


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	44	
(107823) ✓	44	

16X m-1 10/02/02 *

MS21209-F625		Purchased	No				Each	93.0000	4.0000			
												
Heli-Coil												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	93	
(108138) ✓	93	

4X m-1 10/02/02 *

MS24693-C276		Purchased	No				Each	52.0000	16.0000			
												
Screw												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	52	
(8170) ✓	2	
(9599) ✓	50	

16X m-1 10/02/02 *

MS24693-C274
M 113928

16X m-1 10/02/18

(Pto on Back of first page)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

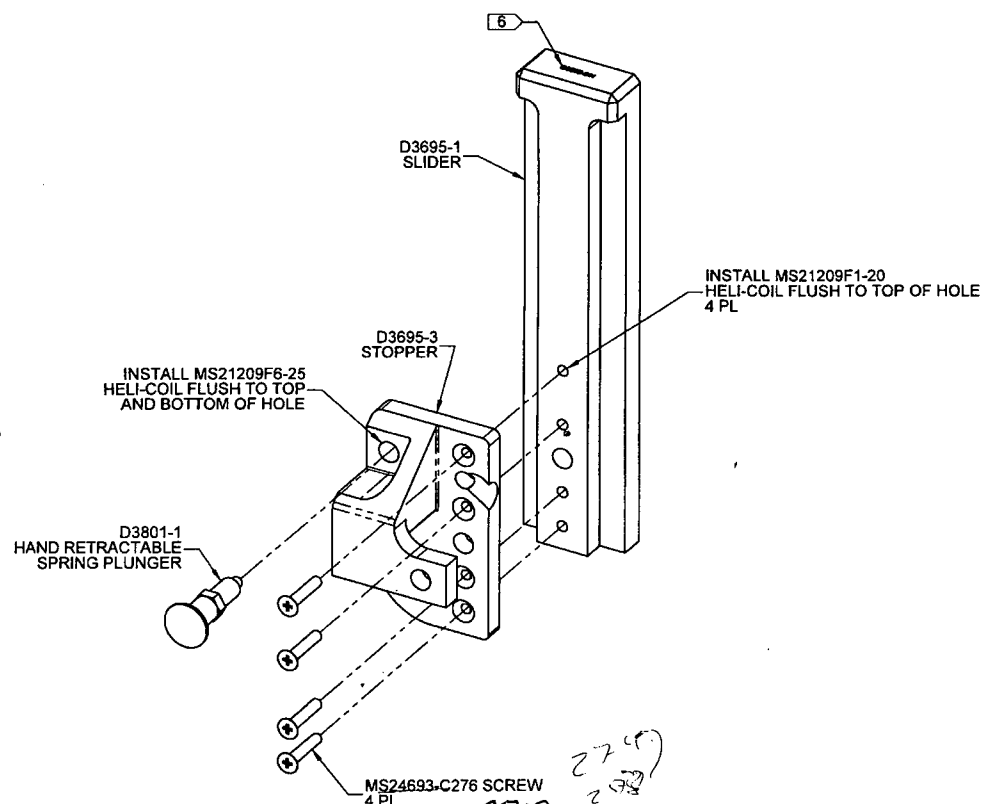
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3695-041	SLIDER ASSEMBLY
11	1	D3695-1	SLIDER
12	1	D3695-3	STOPPER
15	1	D3801-1	HAND RETRACTABLE SPRING PLUNGER
21	4	MS21209F1-20	HELL-COIL, SCREW LOCKING (RED)
22	1	MS21209F6-25	HELL-COIL, SCREW LOCKING (RED)
23	4	MS24693-C276	SCREW



D3695-041 SLIDER ASSEMBLY

D3695-041 NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3695-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: D3695-041 = 0.64 lbs

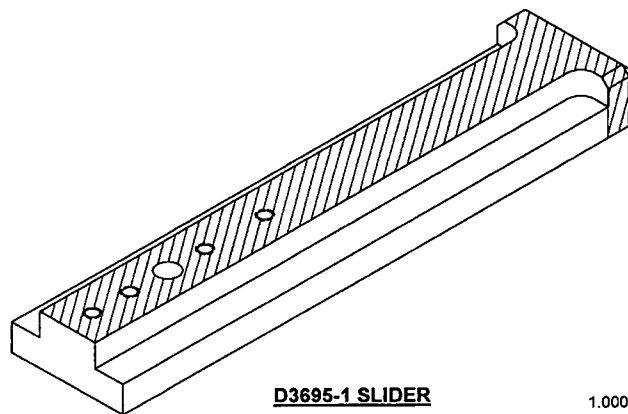
MS24693 - C275 100
C274 100

SHOP COPY
•RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54818

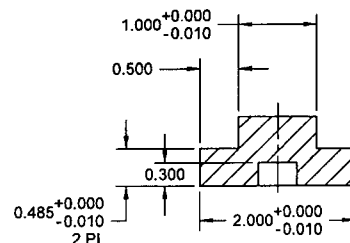
C209/12123

RELEASED
9/62/63 NIP

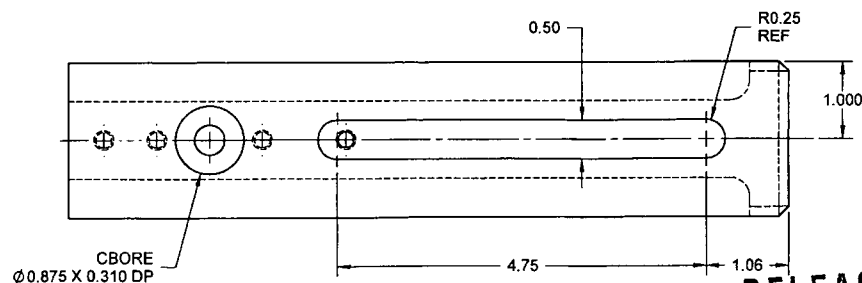
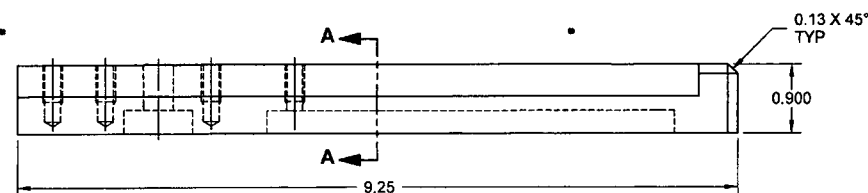
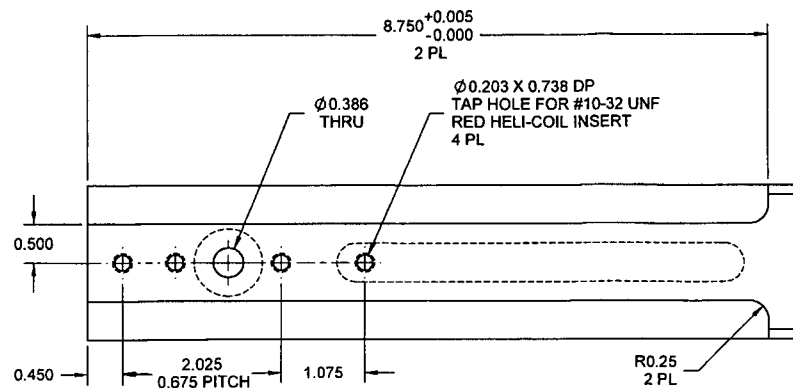
C	UPDATED BOM TO CURRENT STANDARDS; REVISED ITEM 12 (ZN D3-1); DIMS 1.83 AND 1.075 ^{2.00} WERE 1.81 AND 1.063 ^{2.00} (ZN B8-3 AND C4-3). REASON: COMPENSATE FOR PAINT THICKNESS AND ELIMINATE RATTLE UPON ASSEMBLY.	MB	08.11.04
B	P/N D3808-1 WAS WIP-510 (ZN C7-1 AND D3-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3801 SPEC CONTROL DRAWING	MB	08.06.26
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN	1		
DRAWN	1		
CHECKED	1		
MFG. APPR.	1		
APPROVED	1		
DE APPR.	1		
DATE	08.11.04		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3695		REV. C SHEET 1 OF 3	
TITLE SLIDER ASSEMBLY		SCALE NTS	
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D3695-1 SLIDER



SECTION A-A



D3695-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3 - MASK ALL HOLES AND UNHATCHED AREAS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.43lbs

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WITHOUT NOTICE
WORK ORDER

NO. 54918

RELEASED
09/02/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3695	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDER ASSEMBLY	NTS
DATE	08.11.04	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

